3		-	
	*~ ~		
Wai	rk ( )ı	rder III	63365

Page 1

October 28, 2010 8:31:13 AM

<b>T</b> /	TT
Item	111.
140131	11,

D4188-9

**PRELIM** 

**Revision ID:** Item Name:

Spring, Plunger

**Start Date:** 

10/28/10

Start Oty: 6.00



Accept

Run

Setup Start



Stop



Required Date: 11/12/10

Req'd Qty: 6.00



Date:

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date: 10 10 28 Tooling:

SPC (Y/N):

Date:

Date:

Start



Stop

Sequence ID/ **Work Center ID** 

Operation Description

Set Up/ **Run Hours** 

**Tool ID** 

Tool # Plan Code

Accept Qty

Reject Reject **Qty** Number

CX 10/10/28 6

Insp. Stamp

**Draw Nbr** 

**Revision Nbr** 

QC:

D4188

PA1

100

Purchasing

Purchasing

**PURCHASING** 

Issue P/O: 12822

Make as per dwg Possible Supplier: VICTORY SPRING Material release note required

110

Receive & Inspect for Damage & Mat'l Certs

0.00

0.00

0.00

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

120

Quality Control

QC6- Inspect dimensions to drawing

Memo



le 10/4/16 (6)

#### **Dart Aerospace Ltd**

W/O:			SES						
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
·									
Part No	:	PAR #:	Fault Cate	gory:	NCR: Ye	s No DC	  A:	Date:	
				Disposition: Q					
NCR:			WORK ORDI	ER NON-CONFORM	ANCE (N	CR)			
DATE	STEP	Description of NC	Corrective Action Section B			Verif	ication		Approva
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sig Da		tion C	Chief Eng	QC Inspector
		ı							
	1					}			-

### Work Order ID 63365

Page 2

October 28, 2010 8:31:13 AM

Item 1D:

. 4

D4188-9

**PRELIM** 

Spring, Plunger

**Revision ID:** Item Name: Start Date:

QC:

10/28/10

Start Qty: 6.00

Req'd Qty: 6.00



Accept

Setup Start



Stop

Required Date: 11/12/10

Reference:

**Approvals:** 

Process Plan:

Date:

Date:

Tooling: SPC (Y/N):

Date:

Date:

**Cust Item ID:** 

**Customer:** 

Run

Start

Stop

Sequence ID/

Work Center ID

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Memo

Set Up/ **Run Hours** 

0.00

0.00

Tool ID

Tool # Plan

Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

140

QC

**Quality Control** 

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

RELEASED.

## **Dart Aerospace Ltd**

W/O:			W	ORK ORDER CHANGE	S				
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						· · · · · · · · · · · · · · · · · · ·		1 Tod Wgi	
							į		
Part No	•	PAR #:	Fault Cat	egory:	NCR: Yes	No DC	A:	Date: _	
		esolution:							
NCR:			WORK ORE	ER NON-CONFORMA	NCE (NC	7)			
DATE	STEP	Description of NC		Corrective Action Section			ication		Approval
J/((2	0.2.	Section A	Initial	Action Description Chief Eng	Sign		tion C	Chief Eng	QC Inspector
· · · · · · · · · · · · · · · · · · ·	-		Chief Eng	Criter Eng	Date			Office Eng	L C Mopeoner
			Chief Eng	Criter Eng	Date			Officer Errig	
			Chief Eng	Citiet Eng	Date			Office Ling	
			Chief Eng	Cillei Eng	Date			Office Ling	
			Chief Eng	Cillei Eng	Date			Office Ling	
	•		Chief Eng	Cillet Eng	Date			Office Ling	
	•.		Chief Eng	Cillet Eng	Date			Office Ling	
			Chief Eng	Cillet Eng	Date			Office Ling	
	•.		Chief Eng	Cillet Eng	Date			Officer Ling	

NOTE: Date & initial all entries

4 4

Page 1

October 28, 2010 8:31:13 AM

Work Order ID: 63365

Parent Item:

D4188-9

Parent Item Name: Spring, Plunger



**Start Date:** 10/28/10

Required Date: 11/12/10

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP REV:A NEW ISSUE 10-10-19 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4188-9P	1  FF	Purchased	No		100	Each	0.0000	1	6			

Spring, Plunger

[c/s/11/18 6)

### **Dart Aerospace Ltd**

W/O:			W	ORK ORDER CHANGE	S		····-			
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
								. 100 IMg		
								i		
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA	\:	Date:		
	Resolution: Disposition: QA: N/C Closed:									
NCR:			WORK ORD	ER NON-CONFORMAN	ICE (NCR	)		***		
DATE	STEP	Description of NC	1	B Cimp 8	Sign & Verification			Approval		
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Date	Sectio	on C	Chief Eng	QC Inspector	
	1							1	ŀ	
· • • • • • • • • • • • • • • • • • • •										

NOTE: Date & initial all entries

Ø0.022 0.35 SECTION C-C Ø0.22 CX10/10/28 W10'. 63365 **D4188-9 SPRING - PLUNGER** 

NOTES:
1) MATERIAL: STAINLESS STEEL WRE
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 0.00 lbs
8) EXTRA WINDING PERMITTED AT EITHER END OF SPRING

DESIGN	DART AEROS	PACE LTD
DRAWN 8	HAWKESBURY, ONT	ARIO, CANADA
CHECKED	DRAWING NO.	REV. PA1
MFG. APPR.	D4188	SHEET 6 OF 6
APPROVED	TITLE	SCALE
DE APPR.	SPRING	NTS
DATE 10.09.21	COPYRIGHT © 2010 BY DA THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS RE NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COM	PPLIED ON THE EXPRESS CONDITION THAT IT IS MAINICATED TO ANY OTHER PERSON WITHOUT



Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7

Tel: 613 632 9577 Fax: 613 632 1053

#### **PURCHASE ORDER**

#### Purchase Order ID PO12822

Purchase Order Date 10/28/10 PO Print Date 10/28/10

Page Number 2 of 2

Order From:

VC-VIC002

VICTORY SPRING LTD. #2 6104 - 82 AVE. EDMONTON, AB T6B 0E7 CA

Contact Name

Vendor Phone

866 230 5312

Vendor Fax

866 230 5338

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

Net 30

Currency

CAD

10127-2607

**FOB** 

Terms

Destination-Collect

Special Inst:

Special Inst:

AS ABOVE

B63363

11/12/10 Yes 6.00 FedEx Pl ppd

\$38.4200

\$230.52

D4188-7P

D4188-9P

Spring, Pivot

Each

AS ABOVE

B63364

Spring, Plunger

11/12/10

Yes

6.00 FedEx Pl ppd

Each

\$15.0700

\$90.42

Special Inst:

ΛS ΛΒΟΥΕ

B63365

PO Total:

\$839.46

CERTIFICATE OF CONFORMITY REOD UPON DELIVERY



No substitution or deviation without consent.

Certificate of Conformity or Material Certification required when applicable

Change Nbr:

Change Date:

10/28/10



# 2,6104 - 82 Ave Edmonton, AB T6B 0E7 t + 780 442 4020 f + 780 466 8000

## **MATERIAL CERTIFICATION**

Manganese: (Mn) 1.270 Hardness: Molybdenum: (Mo)	
MATERIAL GRADE: T302 Stainless Steel Wire Spring ASTM-313-03  PROPERTIES:  Chemical  Carbon: (C) 0.040  Chromium: (Cr) 17.450  Copper: (Cu)  Manganese: (Mn) 1.270  Molybdenum: (Mo)  ASTM-313-03  Physical  Physical  Size: 0.022  Tensile: 36800 / 32  Hardness:  Molybdenum: (Mo)	RAWING #: PO # PO12822
PROPERTIES:    Dust only   Physical	DESCRIPTION: QUANTITY:
Chemical         Dus only         Physical           Carbon:         ( C )         0.040         Size:         0.022           Chromium:         ( Cr )         17.450         Tensile:         36800 / 32           Copper:         ( Mn )         1.270         Hardness:           Molybdenum:         ( Mo )	AL GRADE: T302 Stainless Steel Wire Spring ASTM-313-03
Carbon: (C) 0.040 Size: 0.022 Chromium: (Cr) 17.450 Copper: (Cu) Tensile: 36800 / 32 Manganese: (Mn) 1.270 Hardness: Molybdenum: (Mo)	TIES: SIUINITES: -INSPECTOD 10 PAI
Chromium:       ( Cr )       17.450         Copper:       ( Cu )       Tensile:       36800 / 32         Manganese:       ( Mn )       1.270       Hardness:         Molybdenum:       ( Mo )	Duy only <u>Physical</u>
Copper: (Cu) Tensile: 36800/32 Manganese: (Mn) 1.270 Hardness: Molybdenum: (Mo)	
Molybdenum: (Mo)	· ,
	( Ni ) 8.250
Nitrogen: (N) 0.050 Heat # H8050	
Phosphorus: (P) 0.028	
Silicon: (Si) 0.290 Sulphur: (S) 0.002	

Certified by: Chris Burrowes

Victory Spring Ltd. certifies this to be a true & accurate copy of the original contained in the company records.



# 2,6104 - 82 Ave Edmonton, AB T6B 0E7 t + 780 442 4020 , f + 780 466 8000

To:

Dart Aero

Attn:

Chantal Lavoie

# **QUOTATION**

It is our pleasure to quote on the following:	Date	27-Oct-10
DESCRIPTION & SPECIFICATIONS	QUANTITY	PRICE
D4188-1 Spring - LH Idle Stop	6	Ca.
D4188-2 Spring - RH Idle Stop	. 6	, <del>de</del> a.
D4188-3 Spring - Idle Stop Limiter	6	a.
D4188-5 Spring - Fly Stop	6	a.
D4188-7 Spring - Pivot	6	
D4188-9 Spring - Plunger	6	
Delivery: 2 weeks ARO		

#### **TERMS & CONDITIONS**

This quotation is subject to review after 30 days. Orders cannot be cancelled except by our consent and on terms which will indemnify us of any loss or damage. Estimates of delivery are subject to change. An over or under run of up to 10% allowed on total parts ordered. Rights reserved to keep all tools manufactured by us. Liability limited to repair or replacement of parts only if they fail to meet specifications or raw material is defective. Under no circumstances shall we be obliged to pay for consequential damages. Springs quoted using commercial tolerances unless otherwise noted. Printed machine tolerances do not apply.

- TAXES EXTRA
- TERMS: NET 30 DAYS

Jeremy Burrowes
VICTORY SPRING LTD.